













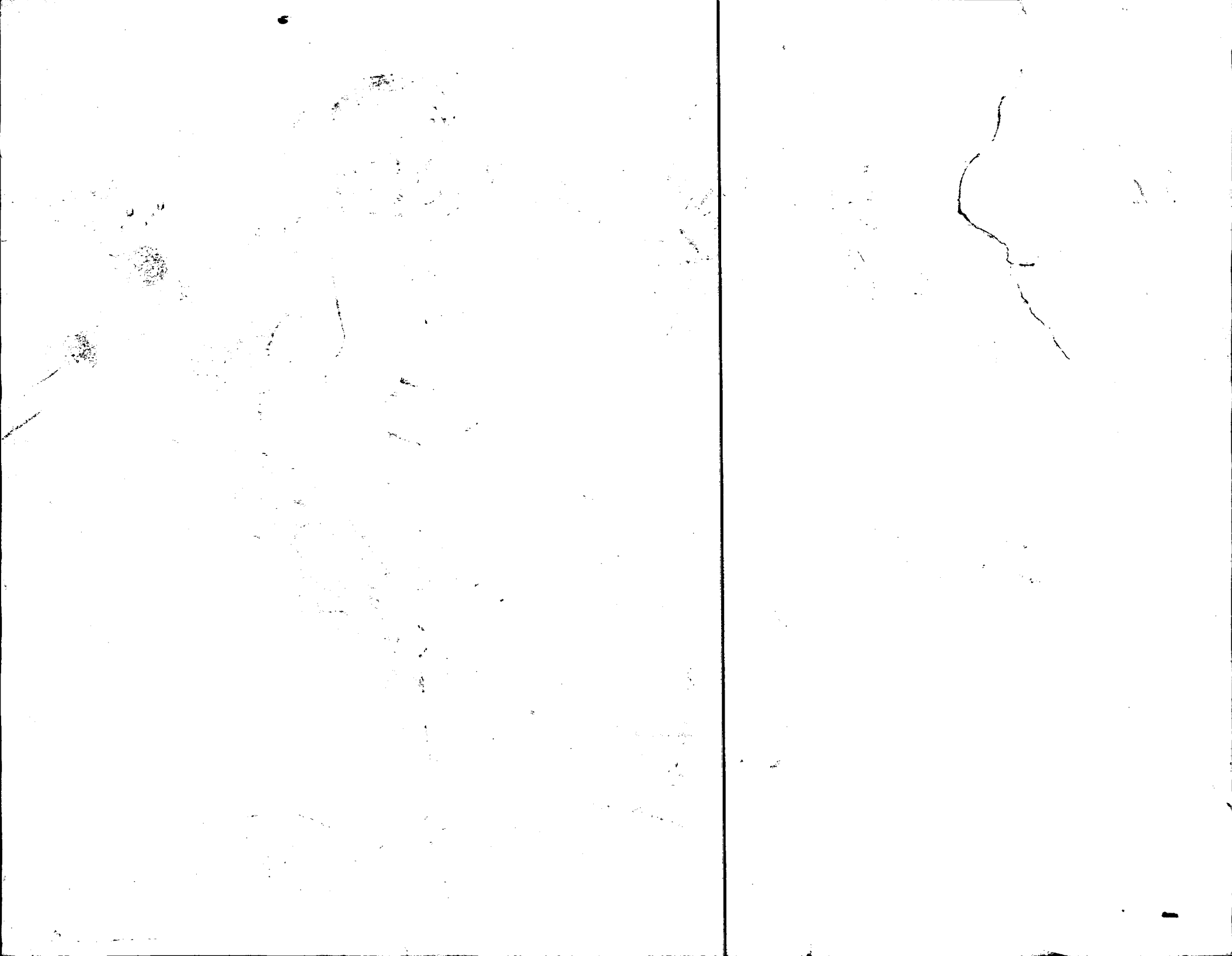


Date: Friday, 5/26/2006 11:40:07 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D26681
Job Number : 27256	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D26681
This Issue : 5/26/2006 S.O. No. : <i>N/A</i>	Drawing Number : RTN 483
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 5/26/2006 Type : <i>N/A</i>	Drawing Revision : <i>N/A</i>
Previous Run : 27255	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/2/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	QC5 INSPECT WORK TO CURRENT STEP
	  <i>06.05.25 (1)</i>
Comment: INSPECT RTN 483	
2.0	D26681 Saddle, LH, Aft, In
	 
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Saddle, LH, Aft, In OLD B/N 20564	
3.0	POWDER COATING POWDER COATING
	 <i>102391</i> 
Comment: POWDER COATING RE-POWDER COAT PER RS1004 <i>FR/</i> <i>02/01/16 (1)</i>	
4.0	QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION
	 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>PC 7/04/16</i>	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	 
Comment: PACKAGING RESOURCE #1 <i>51478</i> ID & STOCK WITH NEW BATCH NUMBER <i>CB 04/01/16 (1)</i>	
6.0	DC DOCUMENT CONTROL
	 
Comment: DOCUMENT CONTROL <i>07/01/17</i>	
Job Completion	 <i>W 02/01/17</i>



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DART AEROSPACE LTD.		Work Order :	20564
Description: 206 Saddle, Inboard, Left Side		Part Number:	D2668-1
Drawing: D2668 Rev. B DEO 9122		Qty:	10

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>SL</i>	04/03/24	10
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length (D6101-001) RF 02/09/16 Batch No: <i>B20570</i>	<i>SL</i>	04/07/13	10
3	HAAS	Program part number and batch number. <i>B20981</i>	<i>SL</i>	04/07/13	10
4	QC	Inspect part number and batch number are programmed correctly.	<i>SL</i>	04/07/13	10
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed <i>04/07/13</i> by <i>SL</i>	<i>SL</i>	04/07/13	10
6	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	04/08/26	10
7	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	04/08/26	10
8	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	04/08/26	10
9	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>EP</i>	04/08/26	10
10	METAL	Deburr	<i>EP</i>	04/08/26	10
11	QC	Inspect Level 1	<i>EP</i>	04/08/26	10
12	QC	Inspect Level 8	<i>EP</i>	04/08/26	10
13	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>EP</i>	04/08/27	10
14	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>EP</i>	04/09/10	10
15	QC	Inspect Level 3	<i>ML</i>	04/09/09	10
16	STORES	Pack in foam, identify and stock.	<i>SL</i>	04/09/10	10
17	EXPEDITING	Close Work Order Job Cost / Part <i>81.38</i> <i>54C 04/09/13</i> <i>(10)</i>	<i>SL</i>	04/09/14	10

Rev	Date	Change	Created By	Approved
A	97.07.24	New Issue		
B	98.09.08	Inspection levels, added powder coat	KS	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	
D	02.03.15	Added DEO 9122	NG	02-03-15

RELEASE

02/03/15 *ML*

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20564
Description: 206 Saddle, Inboard, Left side		Part Number:	D2668-1
Inspection Dwg: D2668 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.127	0.130	0.131	0.129		
B	0.100	0.140		0.127	0.127	0.129	0.133		
C	0.100	0.140		0.125	0.130	0.132	0.132		
D	0.210	0.230		0.224	0.224	0.225	0.221		
E	1.245	1.255		1.247	1.251	1.249	1.252		
F	1.245	1.255		1.247	1.251	1.250	1.252		
G	5.990	6.010		6.003	6.003	6.004	6.003		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.678	1.678	1.678		
J	1.995	2.005		2.000	2.000	2.000	1.997		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.236	0.235	0.235	0.236		
N	0.100	0.140		0.123	0.123	0.125	0.127		
O	1.040	1.060		1.043	1.047	1.049	1.047		
P	0.490	0.510		0.496	0.496	0.499	0.499		
Q	3.609	3.619		3.614	3.611	3.612	3.611		
R	2.470	2.510		2.483	2.506	2.502	2.505		
S	0.240	0.270		0.256	0.256	0.256	0.256		
T	0.100	0.180		0.149	0.149	0.145	0.145		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.133	1.133	1.133	1.128		
W	1.565	1.585	DT8695 A/B	✓	✓	✓	✓		
X	0.050	0.110		0.048					
Y	0.025	"	→	0.025					
Z	0.025	"		0.025					
AA	0.025	"		0.025					
AB	0.025	"		0.025					
AC	0.025	"		0.025					
AD	0.025	"		0.025					
AE	0.025	"		0.025					
AF	0.025	"		0.025					
AG	0.025	"		0.025					
AH	0.025	"		0.025					
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	04/07/13

Audited by:	<i>[Signature]</i>
Date:	04/08/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	20564
Description: 206 Saddle, Inboard, Left side	Part Number:	D2668-1
Inspection Dwg: D2668 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.130	0.131	0.132	0.130		
B	0.100	0.140		0.129	0.133	0.131	0.132		
C	0.100	0.140		0.135	0.134	0.133	0.134		
D	0.210	0.230		0.222	0.225	0.223	0.224		
E	1.245	1.255		1.251	1.251	1.250	1.250		
F	1.245	1.255		1.250	1.251	1.252	1.250		
G	5.990	6.010		6.003	6.003	6.003	6.003		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.679	1.679	1.680		
J	1.995	2.005		1.999	2.002	1.997	2.000		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.236	0.235	0.236		
N	0.100	0.140		0.124	0.124	0.123	0.125		
O	1.040	1.060		1.040	1.040	1.040	1.040		
P	0.490	0.510		0.501	0.500	0.499	0.499		
Q	3.609	3.619		3.612	3.612	3.611	3.611		
R	2.470	2.510		2.504	2.507	2.507	2.505		
S	0.240	0.270		0.256	0.258	0.257	0.258		
T	0.100	0.180		0.143	0.140	0.140	0.139		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.132	1.132	1.131		
W	1.565	1.585	DT8695 A/B						
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	04/08/26

Audited by:	gmk
Date:	04/08/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	#

RELEASED
03.06.18 RF

DART AEROSPACE LTD	Work Order:	20564
Description: 206 Saddle, Inboard, Left side	Part Number:	D2668-1
Inspection Dwg: D2668 Rev. B		Page 1 of 1

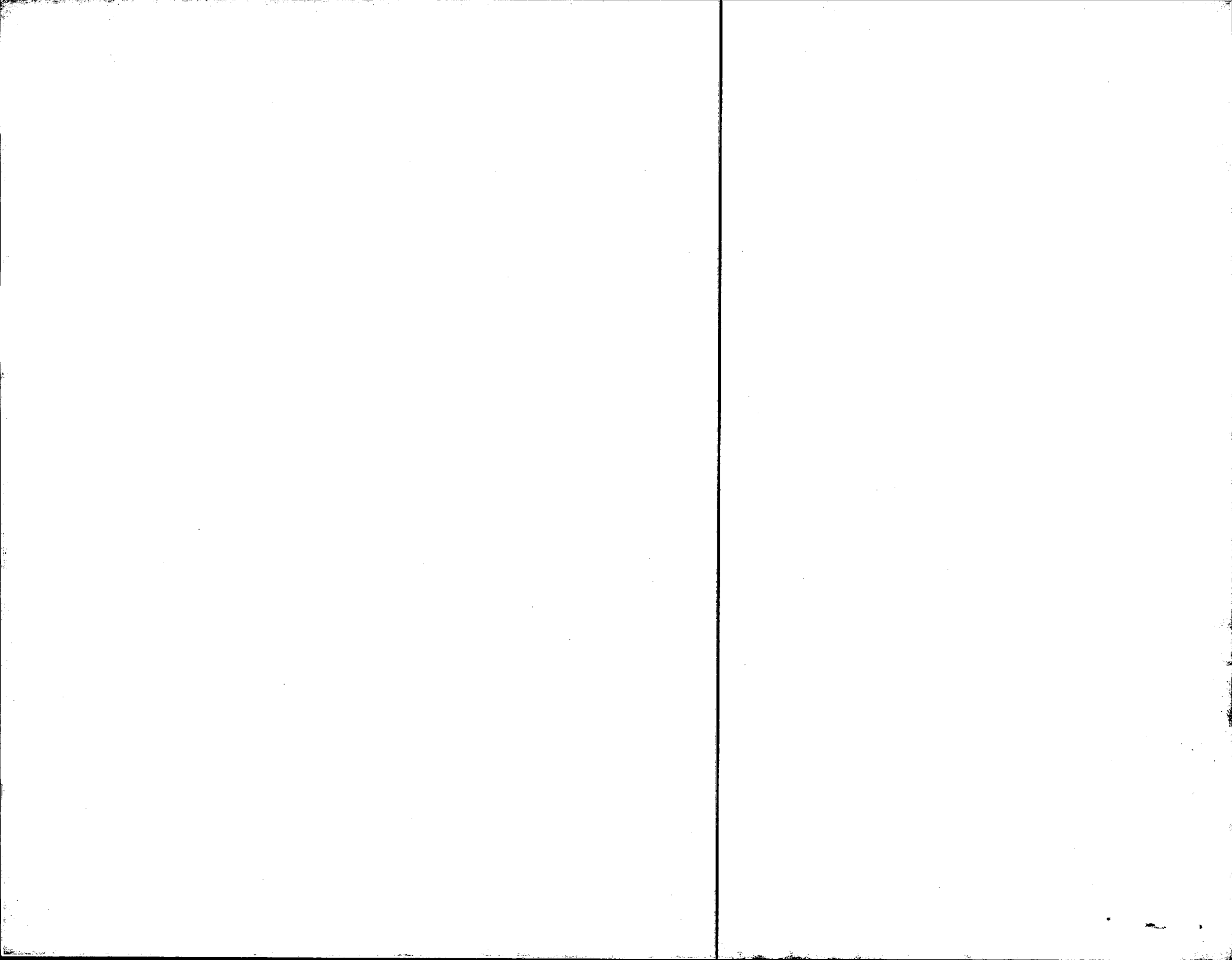
Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.131	0.131				
B	0.100	0.140		0.132	0.133				
C	0.100	0.140		0.136	0.132				
D	0.210	0.230		0.223	0.224				
E	1.245	1.255		1.250	1.249				
F	1.245	1.255		1.250	1.251				
G	5.990	6.010		6.003	6.005				
H	0.510	0.515		0.512	0.512				
I	1.674	1.684		1.680	1.678				
J	1.995	2.005		1.999	1.997				
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.235				
N	0.100	0.140		0.124	0.124				
O	1.040	1.060		1.047	1.048				
P	0.490	0.510		0.504	0.502				
Q	3.609	3.619		3.612	3.612				
R	2.470	2.510		2.507	2.507				
S	0.240	0.270		0.256	0.260				
T	0.100	0.180		0.140	0.141				
U	0.313	0.318	DT8686						
V	1.125	1.145		1.131	1.138				
W	1.565	1.585	DT8695 A/B						
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	04/08/26

Audited by:	972
Date:	04/08/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	#



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 23, 2004
10:58 am

Work Order No	: 0020564	Department Code:	
Project Name	: D2668-1	Burden Flags	: NNNNNNN
Project For	: WK417	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2668-1	Invoice Number	:
Description	: Saddle, LH, Aft, In	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 10	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 03-23-04	Actual Margin	: 0.000%
Est Finish Date	: 04-22-04		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00